

54416

Work Order ID 53868

November 20, 2009 12:57:10 PM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Item Name: Skidtube RH

Stop



Start Date: 20/11/2009 Start Qty: 1.00

Customer Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

RA

Date:

09-11-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

005 per ECN 09-702

HJ for BG 09/11/23

*8
09/12/08*

DSI 9490 Rev. A

B53868

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53868

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Item ID: D350-636-012

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Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 20/11/2009 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Skidtubes

Skidtubes

0.00

0.00

Memo

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R□□□ Aluminum Rod

□ ML12507

10-Grind welds flush as per Dwg D2750

BE 09/11/23

AWM 9-11-24

BE 09/11/23
AWM 9-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start






Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11- scribe batch #.								
120	QC10- Inspect visual per QSI004- ground welds	0.00							
									
QC	Memo	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
									
HandFinish	Memo	0.00							
Hand Finishing									

- AWM 9-11-24

27 Sorulzy

(40)

27 Sorulzy

(40)

p

1 11/9/11/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(Y)

Q

MB 09-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Skidtube RH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 batch: <u>11/1235</u> exp. date: <u>10/12/30</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod batch: <u>M112507</u> <u>BE</u> <u>08/1/30</u>								
	9-Grind welds flush as per Dwg D2750								
	10-Spot face ground handling holes section (total of 4 places perside) as per dwg D2750								

11/11/25

AWM 9-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-636-012

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Setup Start



Revision ID: F

Stop



Item Name: Slidtube RH

Start Date: 08/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-636-012

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Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

M 09/12/01

(X1)

φ

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M112148

Memo

0.00

BR 09-12-01

D

Powder Coating

START TIME: 8:45

OVEN TEMPERATURE: 320

FINISH TIME: 9:15

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

⇒ M 09/12/02

(X1)

φ

Quality Control

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-636-012

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Setup Start



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Item Name: Skidtube RH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

220



HandFinish

HandFinishing

0.00

=> M 09/12/02

0.00

Memo

(X1)

9

Hand Finishing

Install inserts as per dwg D2750

230



HandFinish

HandFinishing

0.00

=> M 09/12/02

0.00

Memo

(X1)

9

Hand Finishing

- ✓ 1-Inspect for Foreign Objects
- ✓ 2-Spray inside of tube with "LPS-3"
batch: N/A
- ✓ 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750
SIKA FLEX 241
BATCH: M112345
EXP DATE: 10/08
- ✓ 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: AA101223
- ✓ 5-Coat all exposed fasteners with "LPS Procyon"
batch: M104251

W/O:		WORK ORDER CHANGES					
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Work Order ID 53868

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Item ID: D350-636-012

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Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



2) 8/12/08

QC

Memo

0.00

Quality Control



250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/12/17 50

260

QC4- 100% Inspect kits for completeness

0.00



2) 8/12/08

QC

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
	<i>h</i>								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

09/12/09 *(1)**09/12/09* *MF**MF 09-12-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 20, 2009 12:57:16 PM

Page 1

Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

ALS4-1032-225		Purchased	No			220	Each	7,324.000	38.0000			
---------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Insert

<u>Warehouse</u>	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse	ST	7324	
	107441	16	
	110768	7308	

AN3C5A		Purchased	No			230	Each	1,118.000	34.0000			
--------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Bolt

<u>Warehouse</u>	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse	ST	1118	
	111424	8	
	111707	69	
	112314	1	
	112641	440	
	113121	300	
	113149	300	

X38 11 09/12/02

X34 11 09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:


Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C6A		Purchased	No			230	Each	904.0000	4.0000			
												
BOLT												

Warehouse Loc Qty Loc Code

Location


Main Warehouse

ST

904

111982

904

AN6C44A		Purchased	No			230	Each	180.0000	4.0000			
												
BOLT												

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST

178

110105

4

110155

14

110665

1

111605

50

111649

50

112720

9

113121

50

x4 41 09/12/02

x4 41 09/12/02

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Parent Item Name: Skidtube RH



Comments:

Start Date: 20/11/2009



Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C35A		Purchased	No			230	Each	144.0000	1.0000			
												
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	144	
102180	1	
106896	1	
110105	48	
110847	94	

AN960C10L		Purchased	No			230	Each	2,658.000	38.0000			
												
washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	2558	
112116	548	
112612	1010	
112933	1000	

x1 41 09/12/02

x38 41 09/12/02

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Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH


Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L  WASHER		Purchased	No			230	Each	260.0000	1.0000			



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	260	
104093	2	
107520	4	
110139	29	
110372	10	
110584	100	
111424	115	

X 08/12/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	402.0000	8.0000			

Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	88	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	6	
43754	2	
44893	33	
45556	1	
48278	29	
Main Warehouse		
ST46	314	
51537	70	
51910	63	
52311	181	

x8 21 09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3488-042RevB Manufactured No



Blade Fitting Assembly, RH

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

19

29043

1

52666

18

D3492-041RevC Manufactured No



Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

140

51584

140

D3492-043RevC Manufactured No



Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

84

52309

84

X1 09/12/02

X8 09/12/02

X8 09/12/02

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53868



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3535-25RevB

Manufactured

No

230

Each

24.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

14

51663

1

51927

13

Main Warehouse

ST

10

52589

10

X1 M 09/12/10

D3536-25RevA

Manufactured

No

230

Each

23.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP10

18

51607

18

Main Warehouse

ST

5

45569

1

47011

2

47526

2

X1 M 09/12/02

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3537-1RevC

Manufactured

No

230

Each

198.0000

3.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

2

48288

2

Main Warehouse

FP17

196

51678

91

51679

105

x3 all 09/12/09

D3631-1RevA

Manufactured

No

230

Each

221.0000

8.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

221

38139

6

45353

16

47437

1

52693

198

x8 all 09/12/09

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Shop Packet Print

Page 8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3791-1RevA		Manufactured	No			230	Each	19.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Wearplate

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

FP

7

51610

7

Main Warehouse

ST

12

51909

12

D3793-1RevA		Manufactured	No			230	Each	27.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Wearshoe

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

27

40551

1

51597

16

51906

10

X1 09/12/02

X1 09/12/02

November 20, 2009 12:57:17 PM

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 20, 2009 12:57:17 PM

Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3RevA  Wearshoe		Manufactured	No			230	Each	23.0000	1.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>51592</div> <div>51903</div> </div> <div>Loc Qty</div> <div>23</div> <div>12</div> <div>11</div> <div>Loc Code</div>												
D3794-1RevA  Gasket		Manufactured	No			230	Each	22.0000	1.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>FP</div> <div>51928</div> <div>Main Warehouse</div> <div>ST</div> <div>46530</div> <div>47212</div> <div>51668</div> </div> <div>Loc Qty</div> <div>12</div> <div>12</div> <div>10</div> <div>1</div> <div>2</div> <div>7</div> <div>Loc Code</div>												

xl 09/12/07

xl 09/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 20, 2009 12:57:17 PM

Work Order ID: 53868



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3794-3RevA

Manufactured

No

230

Each

28.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

24

51598

12

51907

12

Main Warehouse

ST

4

46531

2

47440

1

47722

1

x1 M 09/12/02

MS21043-6

Purchased

No

230

Each

1,040.000

4.0000



NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1040

111424

40

112314

1000

x4 M 09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 20, 2009 12:57:17 PM

Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21083C8

Purchased

No

230

Each

72.0000

1.0000



NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

72

110584

5

111424

2

112492

15

113149

50

NAS1515H3L

Purchased

No

230

Each

266.0000

4.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

40

102472

40

Main Warehouse

ST

226

110450

2

11819

224

X1 M 09/12/02

X4 M 09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1611-010

Purchased

No

230

Each

338.0000

8.0000



O-RING



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

338

110715

44

110915

294

M 09/12/02

PTO =>

NAS1611-013

Purchased

No

230

Each

138.0000

8.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

138

106513

11

111424

20

111758

107

x8 M 09/12/02

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Dart Aerospace Ltd

W/O: 53868		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/12/02		Replace "NAS 1611-010" "ORings FOR 02594-3/ 8 52562	jd	09/12/02	20	W	S 09/12/02

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 20, 2009 12:57:17 PM

Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID: Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A  BOLT		Purchased	No			250	Each	114.0000	2.0000		11/21/09	SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	114	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	2	
111605	50	
111684	4	
112720	50	

AN960C816L



WASHER

Purchased

No

250

Each

260.0000

2.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	260	
104093	2	
107520	4	
110139	29	
110372	10	
110584	100	
111424	115	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53868



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2741RevC

Manufactured

No

250

Each

53.0000

1.0000



Blade, 350 Skidtube

9/12/7 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

20770

0

45320

1

47113

12

51931

40

1 SP

D3493-1RevA

Manufactured

No

250

Each

69.0000

2.0000



Washer

9/12/7 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

69

44902

2

47710

67

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 20, 2009 12:57:17 PM

Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3532-1RevA

Manufactured

No

250

Each

93.0000

2.0000

Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

93

44904

2

52321

91

250

Each

72.0000

2.0000

MS21083C8

Purchased

No

NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

72

110584

5

111424

2

112492

15

113149

50

9/12/7 5

2

9/12/7 5

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1515H8L

Purchased

No

250

Each

81.0000

2.0000

WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

81

107581

34

108964

1

111650

46

110

Each

0.0000

1.0000

D2600-3-BENTRevD1

Manufactured

No

Extrusion Bent

D2744RevC

Manufactured

No

110

Each

67.0000

1.0000

Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

67

44892

1

47488

30

51922

36

9/12/8
137772
2
B 54263

B 52346 BE 09/11/23

① BE 09/11/23

D3672-13
per ECONO 702
L

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53868



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH



Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD  350 I Beam		Manufactured	No			160	Each	1.0000	1.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>47124</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> </div>												
D2743RevB  Crossbolt Spacer		Manufactured	No			160	Each	355.0000	8.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>LG</div> <div>50281</div> <div>51913</div> <div>Main Warehouse</div> <div>ST</div> <div>44891</div> <div>45555</div> <div>48275</div> <div>52310</div> </div> <div> <div>Loc Qty</div> <div>110</div> <div>50</div> <div>60</div> <div>245</div> <div>2</div> <div>57</div> <div>1</div> <div>185</div> </div> <div> <div>Loc Code</div> </div>												

53900

1 14/11/25

8 BE 09/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 20, 2009 12:57:17 PM

Work Order ID: 53868

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3490-3RevA

Manufactured

No

160

Each

65.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

65

45560

1

48276

31

51930

33

4

BE 08/11/30

D3490-1RevA

Manufactured

No

160

Each

112.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112

45338

2

47657

22

48277

48

51932

40

4

BE 09/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

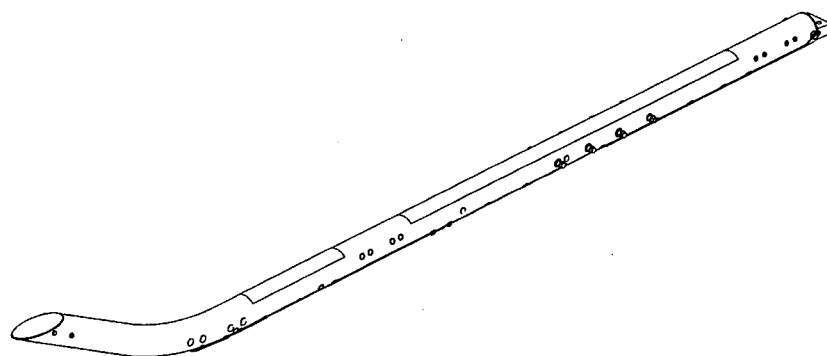
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL Δ
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL Δ

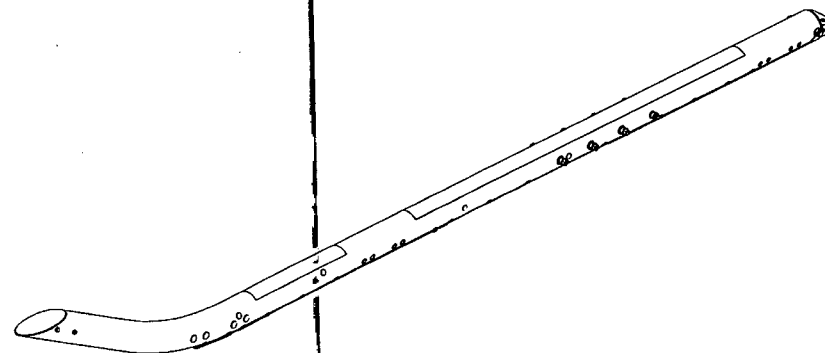
SHOP
RETURN
ENGINE
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53868
BT09-11-20

RELEASED
6-27-22

F	INCORPORATE DSI 0413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 06-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	HL	DRAWING NO.	REV. F
MFG. APPR.	HL	D2750	SHEET 1 OF 11
APPROVED	AMP	TITLE	SCALE
DE APPR.	AMP	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D2750-041 350 SKIDTUBE ASSEMBLY, LH

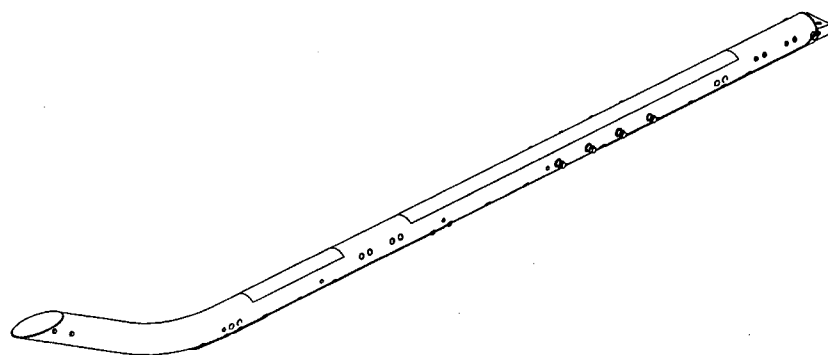


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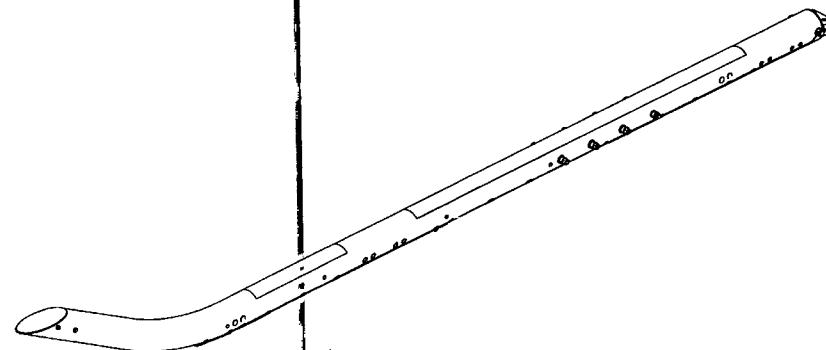
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88 JAN 22 AM

W/O 53868

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DRAWN	AM	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO. D2750	REV. F
MFG. APPR.	SA	SHEET 2 OF 11	
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DE APPR.	SA	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DATE	08.07.16		



D2750-043 350 SKIDTUBE ASSEMBLY, LH

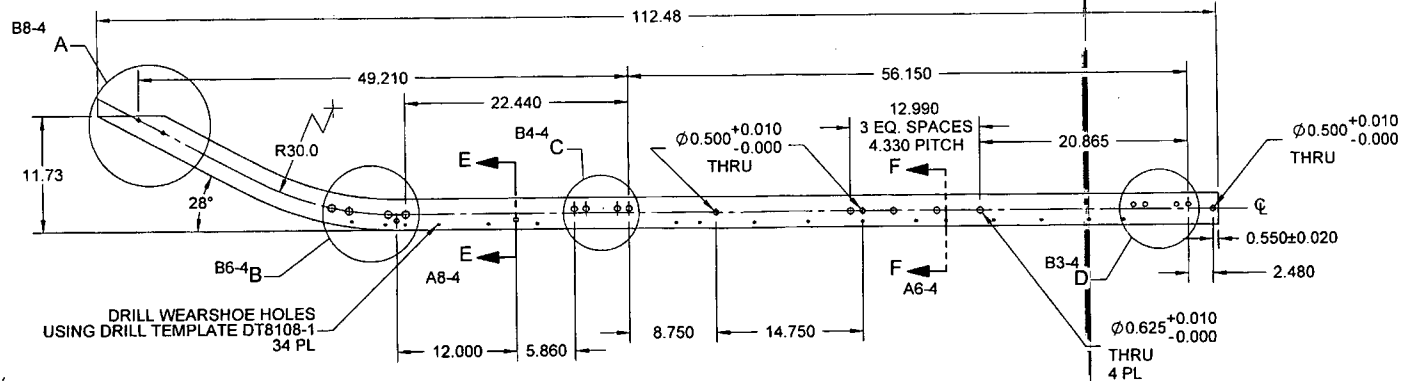


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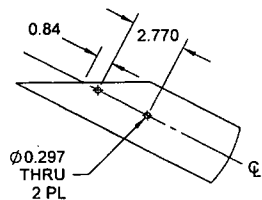
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65-09-221-111

W10 53868

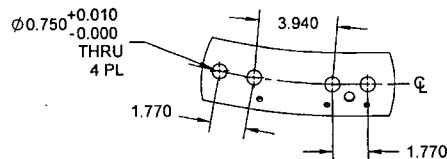
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DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO. D2750	REV. F
MFG. APPR.	PH	SHEET 3 OF 11	
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	350 SKIDTUBE ASSEMBLY NTS	
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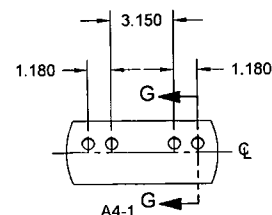
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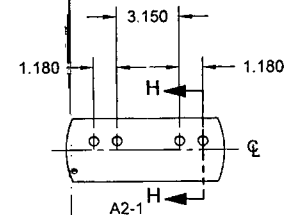
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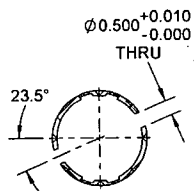
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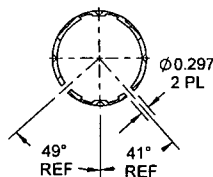
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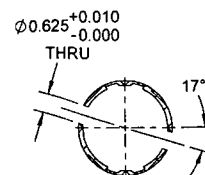
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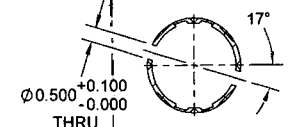
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



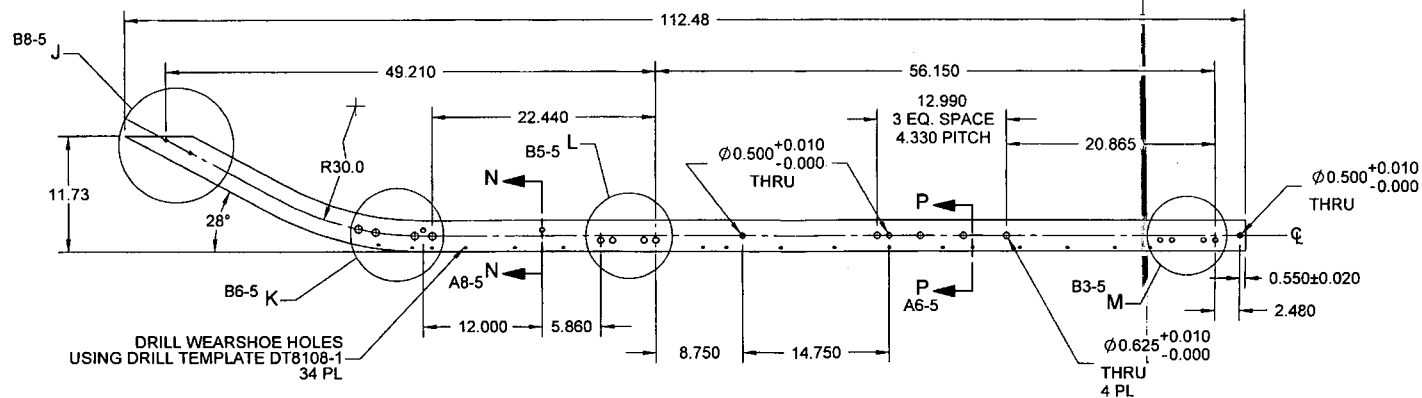
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DRAWN	JP
CHECKED	
MFG. APPR.	
APPROVED	
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DATE	08.07.16

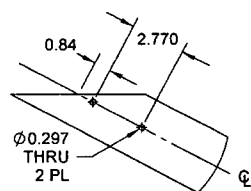
DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D2750	REV. F SHEET 4 OF 11
TITLE 350 SKIDTUBE ASSEMBLY	
SCALE NTS	
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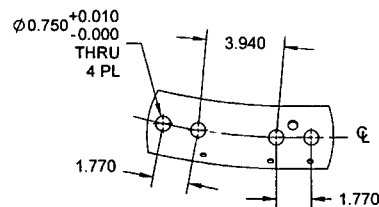
w/lo 53865



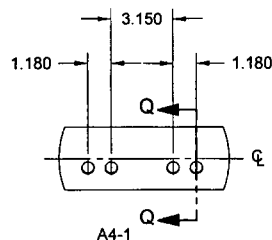
D2750-2 RH SKIDTUBE



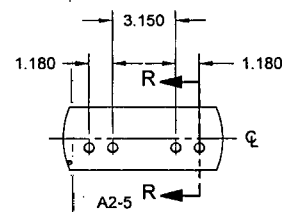
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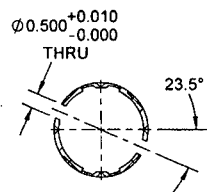
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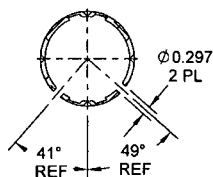
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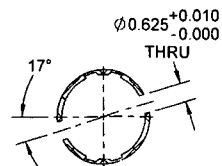
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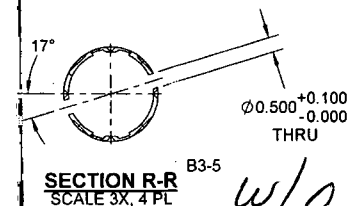
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

RELEASED
W/0 53868

DESIGN	PEA	DART AEROSPACE USA, INC.	
DRAWN	PEA	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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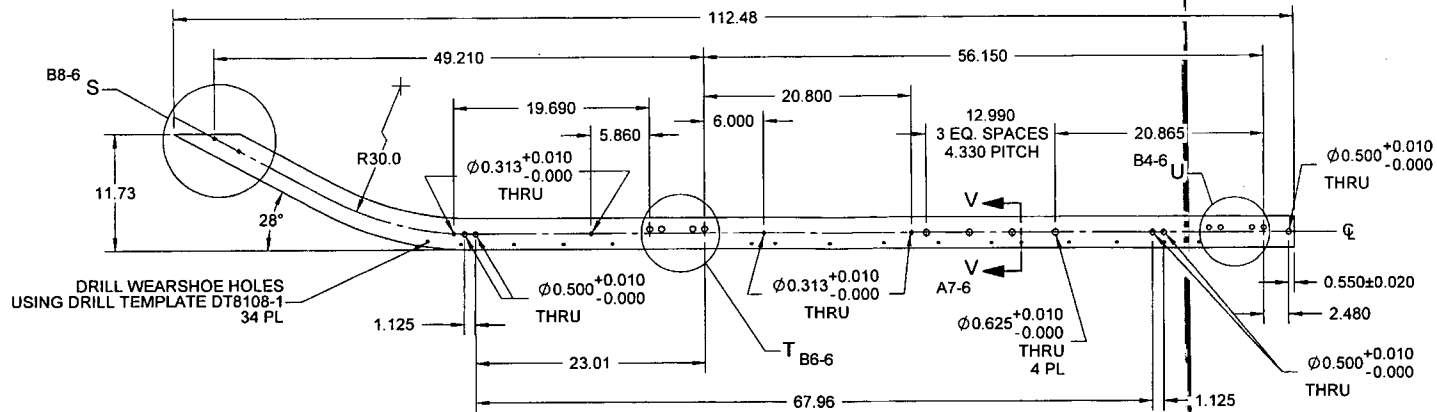
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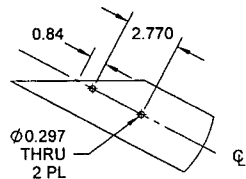
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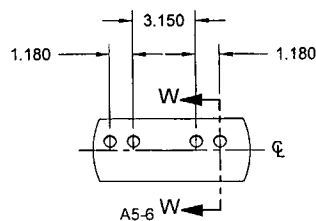
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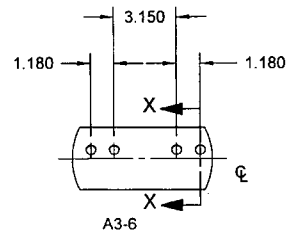
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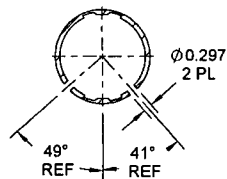
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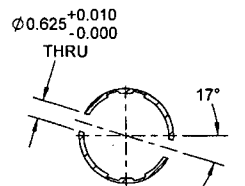
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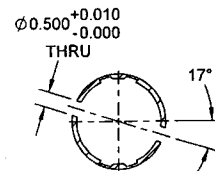
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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W10 53868

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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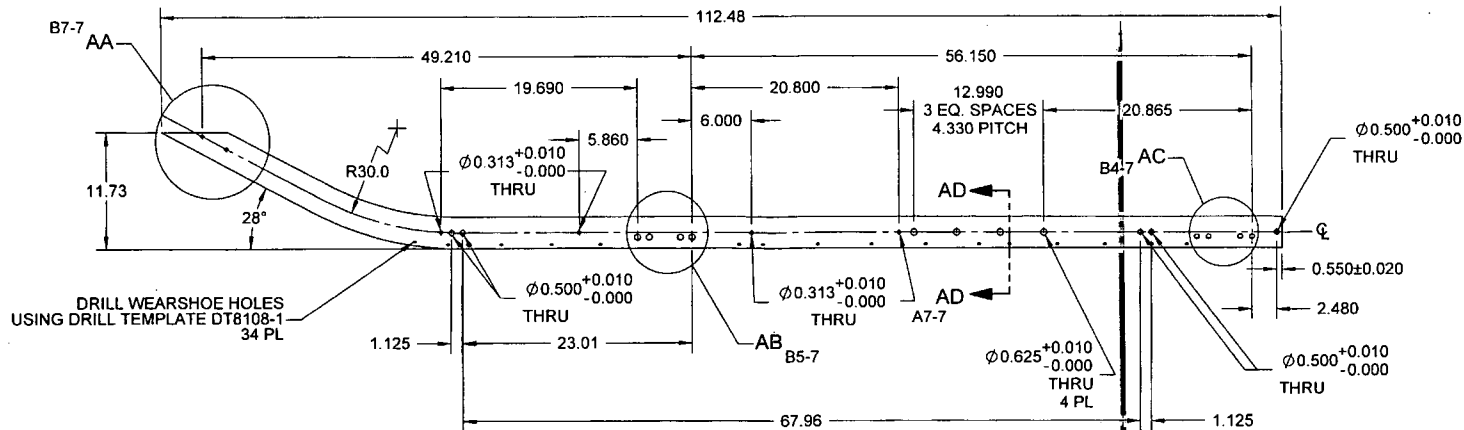
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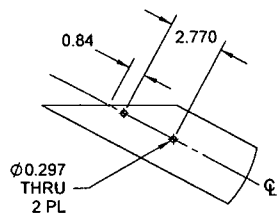
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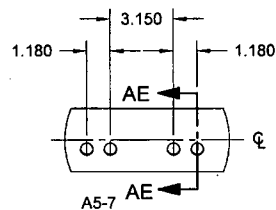


DRILL WEARSHOE HOLES
USING DRILL TEMPLATE DT8108-1
34 PL

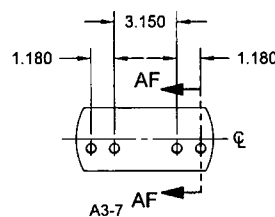
D2750-4 RH SKIDTUBE



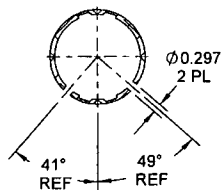
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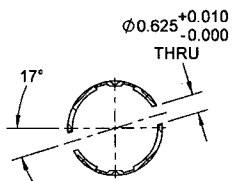
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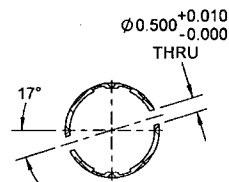
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SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



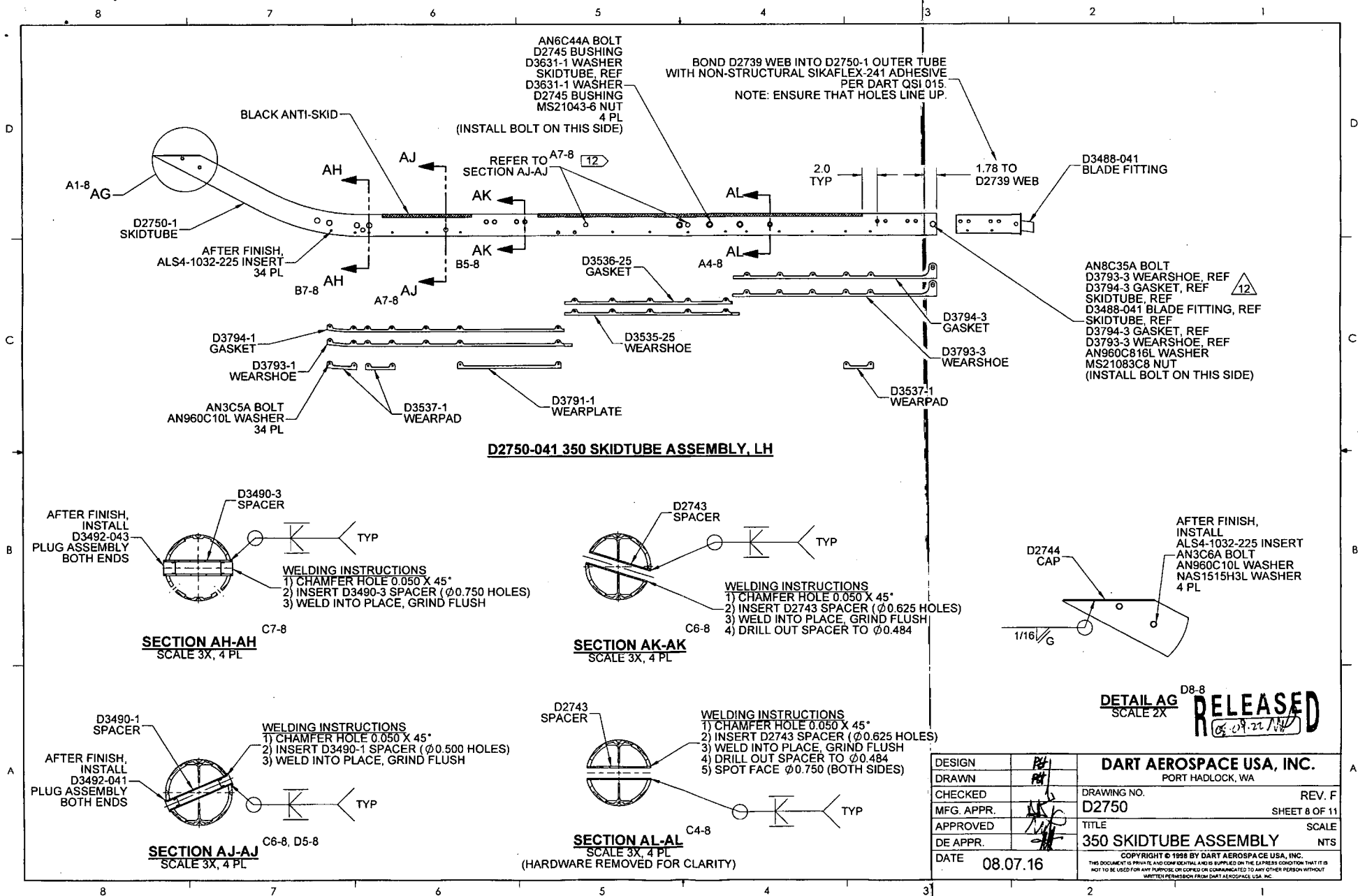
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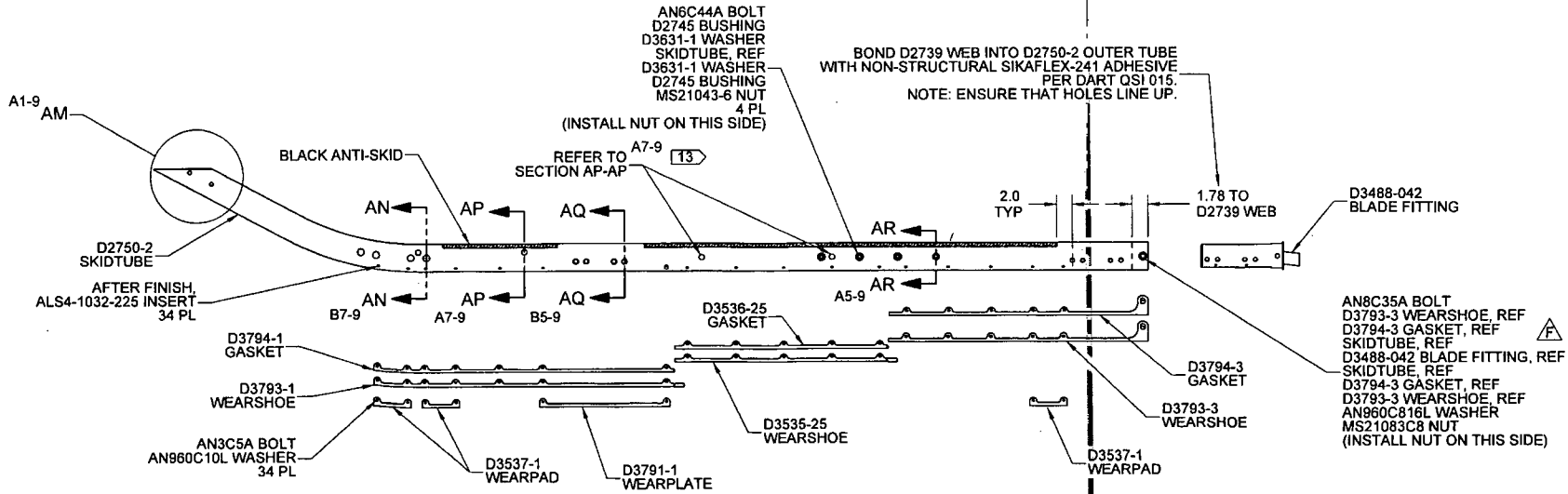
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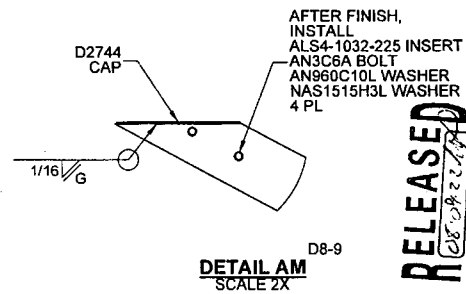
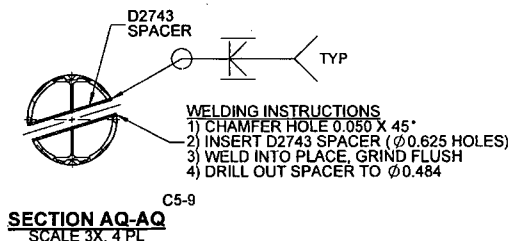
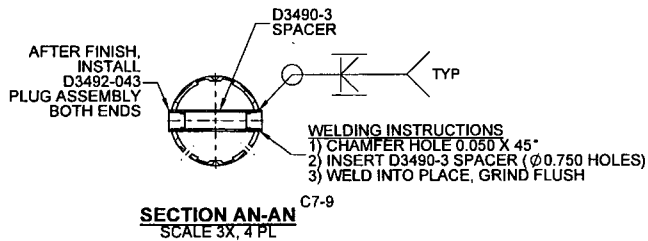
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 7 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
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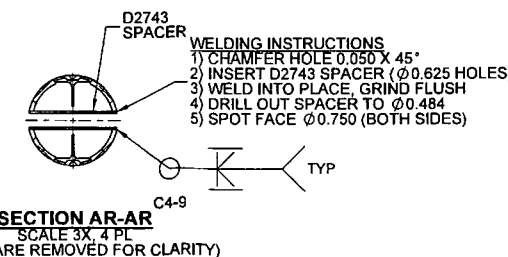
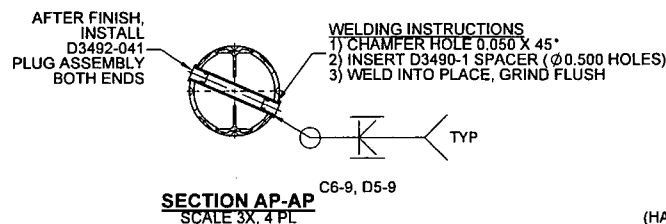
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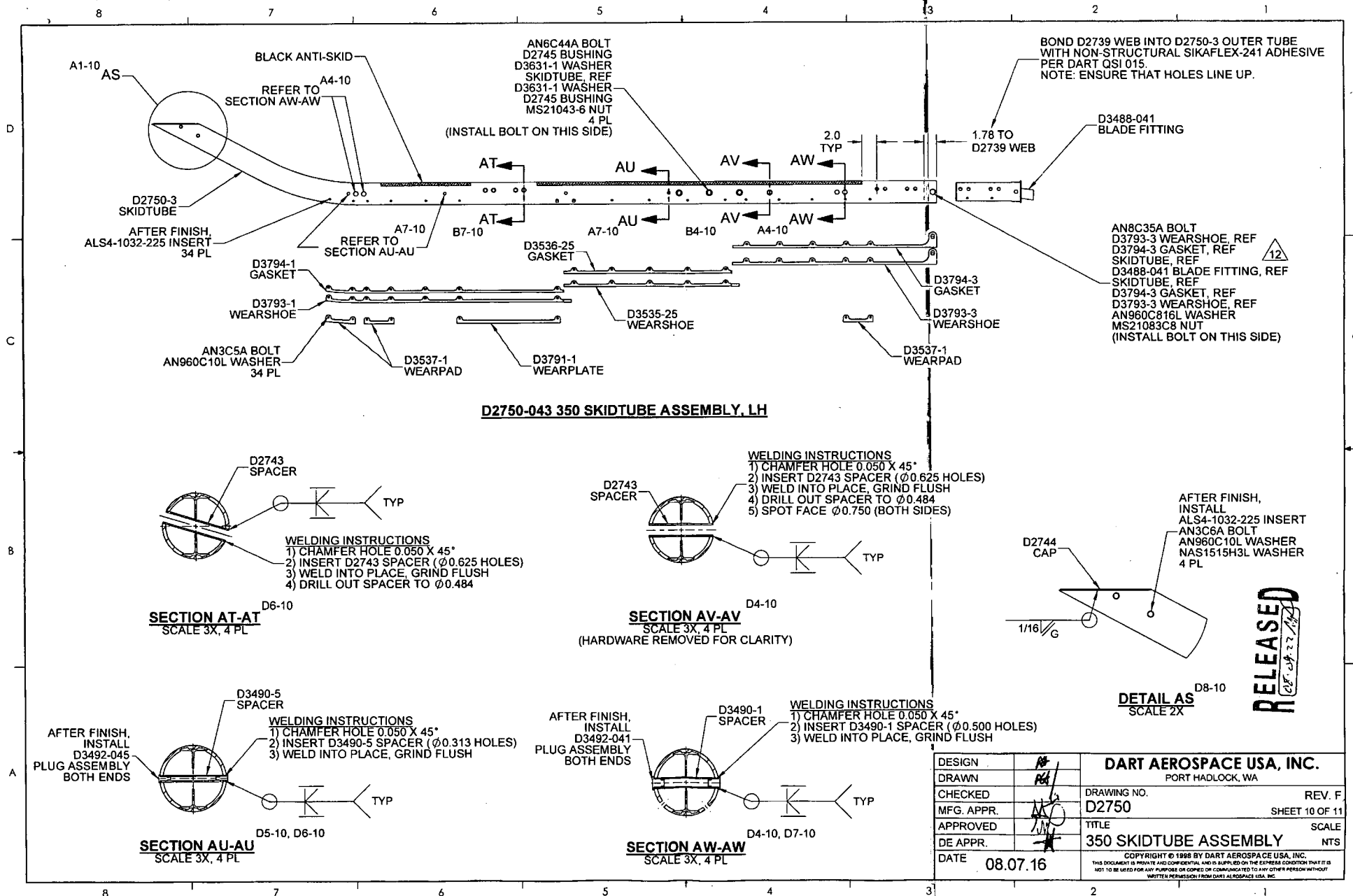
D2750-042 350 SKIDTUBE ASSEMBLY, RH



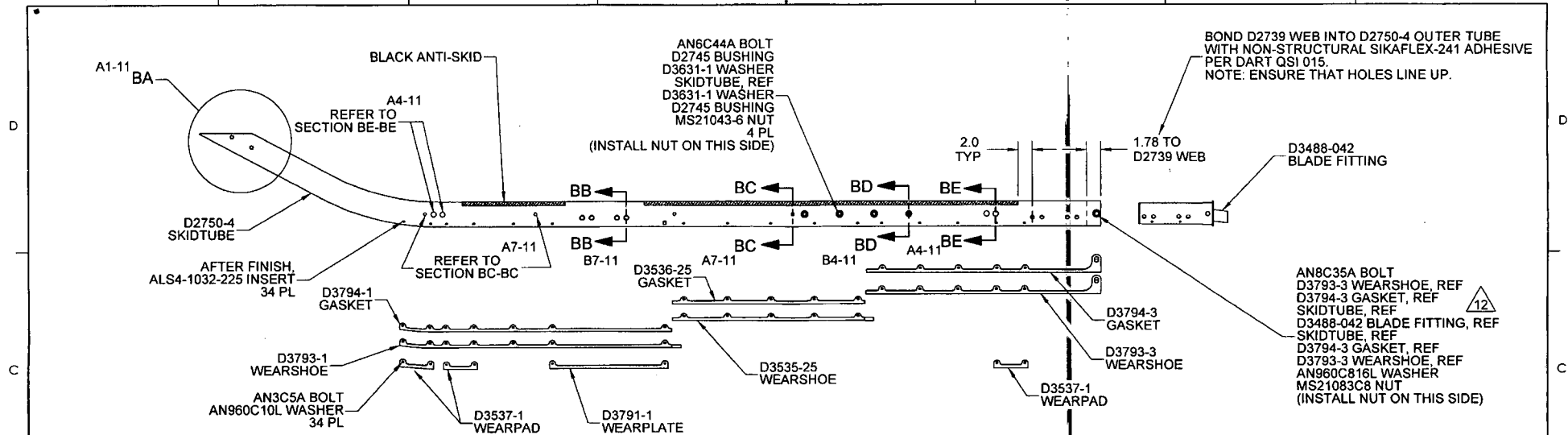
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08-09-2008



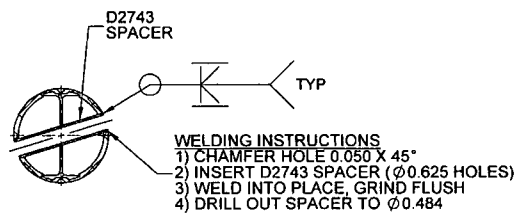
DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	PH	
CHECKED		
MFG. APPR.	MD	
APPROVED		
DE APPR.		DRAWING NO. D2750
DATE	08.07.16	SHEET 9 OF 11
		TITLE 350 SKIDTUBE ASSEMBLY
		SCALE NTS
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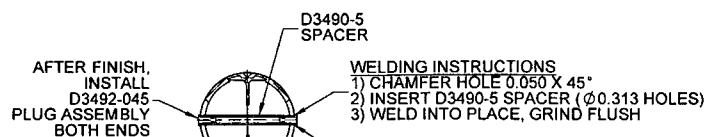
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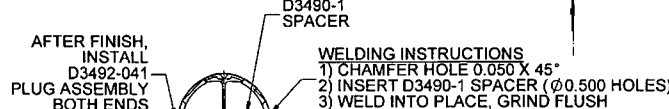
SECTION BB-BB
SCALE 3X, 4 PL



SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL

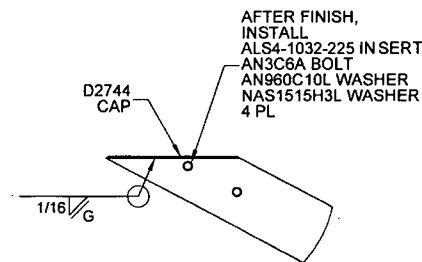


SECTION BE-BE
SCALE 3X, 4 PL

BOND D2739 WEB INTO D2750-4 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL NUT ON THIS SIDE)

RELEASED



DETAIL BA
SCALE 2X

DESIGN	18	DART AEROSPACE USA, INC.	
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CHECKED	18	DRAWING NO.	REV. F
MFG. APPR.	18	D2750	SHEET 11 OF 11
APPROVED	18	TITLE	SCALE
DE APPR.	18	350 SKIDTUBE ASSEMBLY	NTS
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F **REFERENCE ONLY**

REF TCCA STC: SH99-7

REF FAA STC: SR00646SE

PURPOSE:

COMPRESSION OF THE PLASTIC NAS1515H8L WASHER CAN CAUSE LOOSENING OF THE BLADE AT THE END OF THE SKIDTUBE.

CHANGE:

FOR D350-636-011/-012/-013/-14 SKIDTUBES AT CHANGE 005 OR LATER AND D350-636-103/-104 KITS AT CHANGE 002 OR LATER, THE QTY (2) NAS1515H8L WASHERS ARE REPLACED WITH PHENOLIC D3672-13 WASHERS. FOR SKIDTUBES AND KITS AT AN EARLIER CHANGE NUMBER, IT IS ACCEPTABLE TO REPLACE NAS1515H8L WASHERS WITH D3672-13 WASHERS. THE PARTS LIST OF INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F IS AMENDED AS FOLLOWS:

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -103	QTY -104	PART NUMBER	DESCRIPTION
	X						D350-636-011	SKIDTUBE INSTALLATION, LH
		X					D350-636-012	SKIDTUBE INSTALLATION, RH
			X				D350-636-013	SKIDTUBE INSTALLATION, LH
				X			D350-636-014	SKIDTUBE INSTALLATION, RH
					X		D350-636-103	APICAL FLOAT INSTALLATION KIT, LH
						X	D350-636-104	APICAL FLOAT INSTALLATION KIT, RH

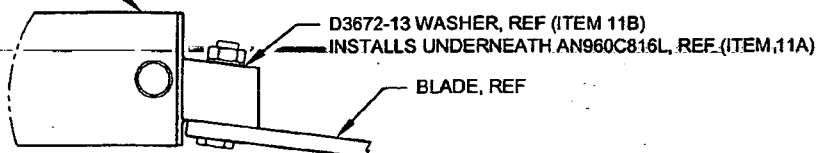
IS:

11B	2	2	2	2	2	2	D3672-13	WASHER
-----	---	---	---	---	---	---	----------	--------

WAS:

11B	2	2	2	2	2	2	NAS1515H8L	WASHER
-----	---	---	---	---	---	---	------------	--------

AFT END OF SKIDTUBE, REF



**LOCATION OF WASHER
(DETAIL D OF IIN-D350-636)**

A	NEW ISSUE, PAR 09-038	CP	09.11.04
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. DSI 9490 TITLE WASHER CHANGE SCALE NTS COPYRIGHT © 2009 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	REV. A	
DRAWN		SHEET 1 OF 1	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.04		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 213

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 851620
Part number: 1350-636-012
Description: 350 Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David David Date of Test Coupon 09/10/22
Welder Barclay Elliott Date of Test Coupon 09/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld